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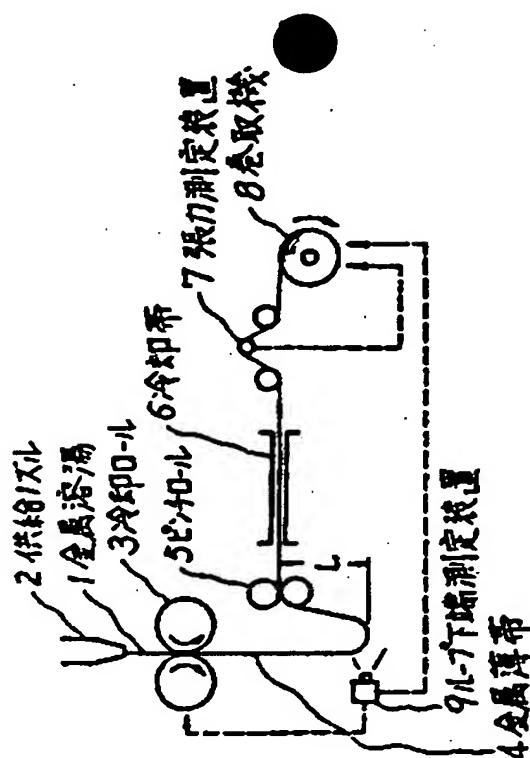
APPLICATION NUMBER : 61296674

APPLICANT : KAWASAKI STEEL CORP;

INVENTOR : SHIBUYA KIYOSHI;

INT.CL. : B22D 11/06 B21C 47/00 B21C 47/02

TITLE : METHOD AND EQUIPMENT FOR PRODUCING RAPID COOLING STRIP



ABSTRACT : PURPOSE: To easily wind a material having low ductility at high temp. without any strip breakage by passing the strip under loop-forming absorbing fluctuation of tension caused by fluctuation of winding speed at a part from just after solidification by rapid cooling to reaching to winding machine.

CONSTITUTION: Molten metal 1 is supplied to a part between cooling rolls 3, 3, from a supplying nozzle 2 and after changing the advancing direction of a metallic strip 4, which is solidified by cooling rapidly, by pinch rolls 5, the strip is wound to a winding machine 8 under tension control by a tension measuring device 7 through cooling zone 6. Then, by adjusting the number of revolution for the cooling rolls 3, the loop of strip 4 is formed at the region between the cooling rolls 3 and pinch rolls 5 to hold the slack at the hot temp. part in the strip 4. Further, the lowest position of loop for the strip 4 is observed by a loop lowest position measuring device 9, and the lowest position of loop is controlled, so as to position always at the aimed range. In this way, the material having little ductility at high temp. is easily wound without any strip breakage.

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